



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA6A-100
Job Sheet 169552



Part No: SWA6A-100

Job Qty: 10 ea

Part Name: Lower End



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/13/17

Job Tracking No:

Due Date: 12/29/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA6A-100 Rev7 IPP Rev A 17.11.15 New issue

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	12/28/17	12/28/17	0.00	0.00	Start Up Machining-3		
100	Bandsaw	10 pcs	12/28/17	12/28/17	0.00	1.00	Bandsaw1		
110	Mori Seiki	10 pcs	12/29/17	12/29/17	0.00	10.00	MORI NLX		
120	QC	10 pcs	12/29/17	12/29/17	0.00	0.00	QC2		
130	QC	10 pcs	12/29/17	12/29/17	0.00	0.00	QC8		
140	Packaging	10 pcs	12/29/17	12/29/17	0.00	0.00	Packaging3	6A	
150	QC21-SA	10 Ea	12/29/17	12/29/17	0.00	0.00	QC21		

Part Op 100 - Cut blanks to 5.90".

Descriptions: 110 - 1-Machine as per DWG.FB703 FOLIO REV: _____ DWG REV: _____ 2-Debur

DAS
21
0-C3

JAN 1 8 016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R2.500	5	13	0	0

Part Specifications

Specifications could not be found.

Plex 1/15/18 10:59 AM Dart.lajeunesse.marie

6432

DART
AEROSPACE
S032354

Dart Aerospace Ltd.

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CANADA
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Lower End

PART NO: SWA6A – 100

Original Serial #: S032354

Revision:

Operation:

Change No:

Start up Operation 01/15/18

Job No: 169552

DART AEROSPACE LTD		Work Order:
Description: <u>Lower end</u>		Part Number:
Inspection Dwg: <u>SWAGA-100</u> Rev: <u>7</u>		Page 1 of <u>1</u>

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
$\varnothing .91$	$\pm .01$	.915			Vern LPO4	
.58 x 45°	$\pm .01 \times .5^\circ$	.570 x 45°			↓	
1.030	$\pm .005$	1.030			Height gauge	
$\varnothing .890$	$\pm .015 / -.000$	.898			Mic LPO4	
.04 x 45°	$\pm .01 \times .5^\circ$	.04 x 45°			Vern LPO4	
R.03	$\pm .01$	.032			↓	
$\varnothing 1.109$	$\pm .005$	1.110			Mic LPO4	
R.03	$\pm .01$	.032			Regrange	
.030 x 45°	$\pm .01 \times 45^\circ$	.03 x 45°			Vern LPO4	
$\varnothing 1.126$	$\pm .005 / -.000$	1.1285			Mic LPO4	
1.00	$\pm .01$	1.002			Vern LPO4	
3.05	$\pm .01$	3.060			↓	
R.13	$\pm .01$	.125			R Gauge	
R.220	$\pm .005$	.218			↓	
$\varnothing 2.32$	$\pm .01$	2.320			Vern LPO4	
$\varnothing 2.06$	$\pm .01$	2.060				
.890	$\pm .005$	.890				
1.14	$\pm .000 / -.020$	1.130				
.03 x 45°	$\pm .01 \times .5^\circ$	.03 x 45°				
R.13	$\pm .01$	.125				
10-32 UNF J.25	G0 - NO G0	G0				
$\varnothing .500$	$\pm .005$	.503				
.820	$\pm .005$	.825				
10-32 J.88	G0 - NO G0	G0				
.200	$\pm .005$	.198			Mic LPO4	
$\varnothing 1.560$	$\pm .002$	1.560			Mic LPO4	
$\varnothing 1.720$	$\pm .000 / -.002$	1.769			↓	
.400	$\pm .005 / -.000$	.403			Vern LPO4	
1.550	$\pm .005$	1.549			Height gauge	
2.350	$\pm .005$	2.349			↓	
5.74	$\pm .01$	2.742			Vern LPO4	

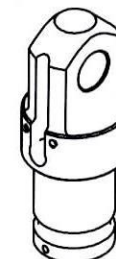
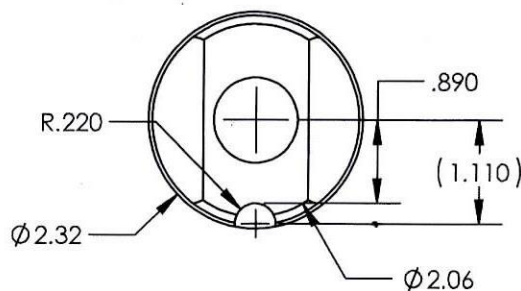
Measured by: <u>[Signature]</u>	Checked by: <u>[Signature]</u>	QC Inspector:
Date: <u>18-01-14</u>	Date: <u>18/01/16</u>	Date:

Engineering Approval: <u>[Signature]</u> (if necessary)	Date:
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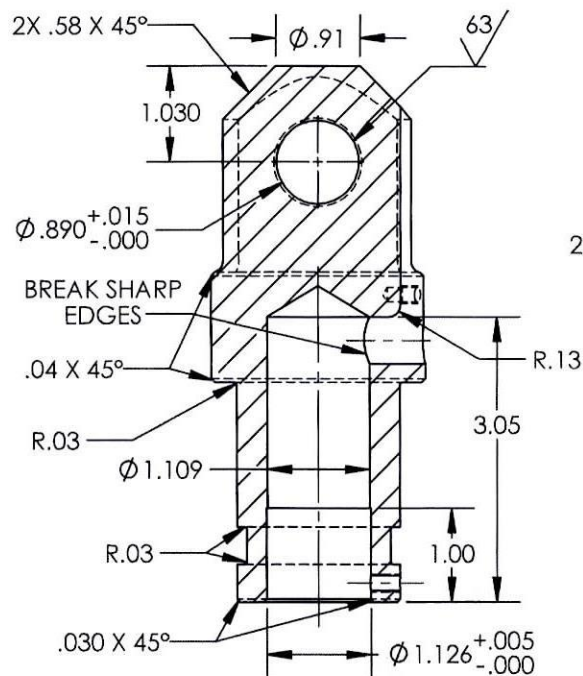
Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

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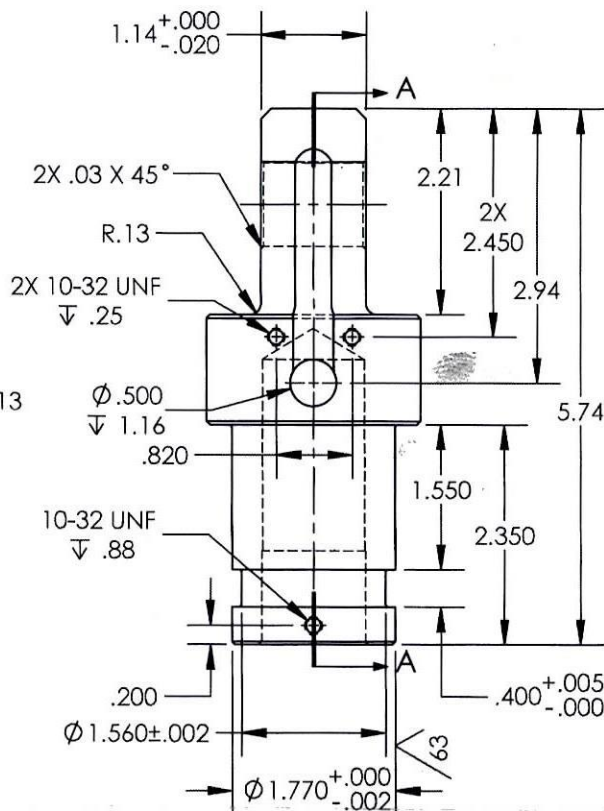
REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
6		AS DRAWN BY CANAM.			11/15/2012	JAG
7	15-0088	CH'D DIMENSION OF TOP FLANGE WAS 1.14 IS 1.14 +.000 -.020.			4/16/2015	RJC JAG



SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169552 M05
17-12-13



SECTION A-A



DART AEROSPACE	
TITLE LOWER END	
DWG NO. SWA6A-100	REV 7
MAT'L SS 17-4, H1075, H1150	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 2/1/2002
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA6A-100	1	LOWER END	SS 17-4, H1075, H1150	Ø2-1/2 X 5-7/8

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: Date:

Work Order update only ☐

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: M17-4-H1150-R2.500 Revision: 17-4 SS H1150 Round Bar 2.500"														
100	Receive Ft	S032346	169552	2 ft	0		Start Up Machining-3		Stock	1/15/2018	Issue Container			
		S032347	169552	6 ft	0		MAT		Stock	1/15/2018	Issue Container			
Operation Totals:		2		8	0									
Part Totals:		2		8	0									
Part Number: SWA6A-100 Revision: Lower End														
150	QC21-SA	S032354	169552	10 Ea	0	S032354	GA		Stock	1/15/2018	Issue Container			
Operation Totals:		1		10	0									
Part Totals:		1		10	0									
Totals:		3		18	0									

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					